

IN THE CLAIMS:

1. (Amended) A composition for lubricating metallic work pieces comprising:

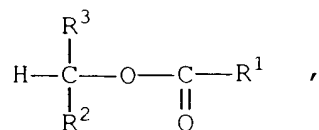
(a) an oil having a viscosity of about 75 cSt to about 160 cSt at 25°C;

(b) free sulfur in an amount sufficient to provide lubrication, and

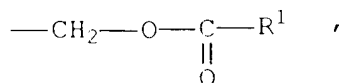
(c) a metal corrosion inhibitor to prevent corrosion of said work pieces;

wherein said lubrication is demonstrated by a Falex reference load of greater than about 4,500 pounds force and by a Falex reference wear of less than ten teeth [measurements selected from the group consisting of Falex reference wear, Falex reference load, Four-Ball wear scar diameter or combinations thereof].

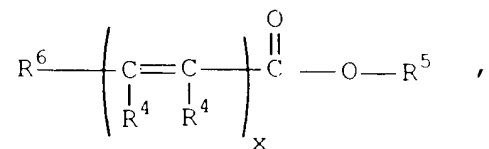
3. (Amended) The composition of Claim 1, wherein said metal corrosion inhibitor is a fatty oil selected from the group consisting of a glyceride, an ester of a carboxylic acid, and combinations thereof, wherein said glyceride is represented by the formula of



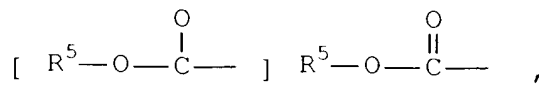
wherein R¹ is a saturated or unsaturated C₃ to C₂₄ aliphatic hydrocarbon, and R² or R³ is hydrogen or



wherein R¹ is as defined above, and said ester is represented by the formula of



wherein R⁴ is hydrogen or a saturated or unsaturated C₃ to C₁₂ aliphatic hydrocarbon, X is 1, 2 or 3, R⁵ is a saturated or unsaturated C₃ to C₂₄ aliphatic hydrocarbon, and R⁶ is represented by the formula of



wherein R⁵ is as defined above.

4. (Amended) The composition of Claim 3 [1], wherein said fatty oil is about 5 to about 30 volume percent based on said composition.

Cancel claims 7 and 8 without prejudice.

11. (Amended) A composition for lubricating nonferrous metallic work pieces comprising:

(a) an oil having a viscosity suitable for heavy duty metalworking operations; and

() free sulfur being present () amounts of about 0.4 percent to about 12 percent by weight of said composition; wherein said composition does not corrode said nonferrous work pieces.

20. (Amended) A method of making a composition which provides non-corrosive lubrication to nonferrous metalworking processes comprising:

selecting a base oil having a viscosity of about 75 cSt to about 160 cSt at 25°C;

incorporating chemically unbound sulfur to said base oil to provide an extreme pressure lubricant, wherein the chemically unbound sulfur is incorporated in an amount from about 0.4 to about 12 weight percent of said composition; and

further incorporating a fatty oil to inhibit nonferrous metal corrosion.

24. (Amended) A method of providing non-corrosive lubrication to the metalworking of a nonferrous metal part[s] comprising:

providing a composition which includes a base oil having a viscosity of about 75 cSt to about 160 cSt at 25°C and free sulfur present in amounts sufficient to provide extreme pressure lubrication of a Falex reference load of greater than about 4,500 pounds force; and

applying said composition to the metal work part [piece] and/or a metal work tool during the metalworking process.